

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017777**Date Inspected:** 03-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, NORTH TOWER LIFT 5, GRILLAGE PLATE (NWIT # 06840)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as Tower components. The weld designations reviewed are as follows:

NSD1-TL5-3F-F-001A/B, 004A/B

NSD1-TL5-3E-F-010A/B, 016A/B

NSD1-TL5-3B-F-018A/B, 020A/B

BAY 10, NORTH TOWER LIFT 5, GRILLAGE PLATE (NWIT # 06844)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as Tower components. The weld designations reviewed are as follows:

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NSD1-TL5-3E-F-009A/B, 015A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

TOWER FACADE SUBASSEMBLY

During random in process inspection this QA inspector observed that ABF NDT personnel performing Magnetic Particle Testing (MT) on the weld joints of Tower facade subassembly of skin A of 109M elevation. The members are identified as Tower components and the weld designations reviewed are as follows.

SMAW welding of weld joint 007 located on SD1-SFSA3-24-1.

Welder is identified as 053829. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

BAY 11, OBG BIKE PATH

SMAW welding of weld joint 115 & 116 located on BK004A6-020.

Welder is identified as 040655. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joint 024 located on BK004A8-017.

Welder is identified as 042218. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2132.

FCAW welding of weld joint 014 and 015 located on BK005B4-004.

Welders are identified as 040723, 054460, 066746 & 067138. ZPMC CWI is identified as Mr. Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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